



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20-8713

D2731-7

Job Sheet 206276-A



5255138

Part No: D2731-7

Job Qty: 28 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/20

Job Tracking No:

Due Date: 3/19/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C IPP D 00.05.19 Added inspect level 8, removed P/O powder coating EC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	
120	Packaging 2-1 - Receive - B4B	28 pcs		3/19/20	0.00	0.00	
						Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
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						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
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						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	

					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
130 QC 6	28 pcs	3/19/20	0.00 0.00		QC 6 - 9	DAS 82 9-89 MAR 03 2020
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
131 Rework - 2 - B4B	28 pcs	3/19/20	0.00 0.00		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
132 Rework - 3 - B4B	28 pcs	3/19/20	0.00 0.00		QC 5 - 9	
					QC 5 - 81	
133 Rework - 4 - B4B	28 pcs	3/19/20	0.00 0.00		Powdercoat - 1 - B4B	
134 Rework - 5 - B4B	28 pcs	3/19/20	0.00 0.00		QC 3 - 9	
					QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	28 pcs	3/19/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
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180 QC 21 - SA	28 pcs	3/19/20	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 120 - (Receive & Inspect for Damage & Mat'l Certs) ENSURE C OF C IS ATTACH.

Descriptions: 130 - (QC6- All purchased or subcontracted products)

131 - 1-Hand finish, chemically remove powder coat and touch up ALODINE if required. 2-Prepare for powder coat

132 - (QC5- Inspect part completeness to step on W/O)

133 - (Powder coat gloss white as per DART QSI 005 4.1) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

134 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

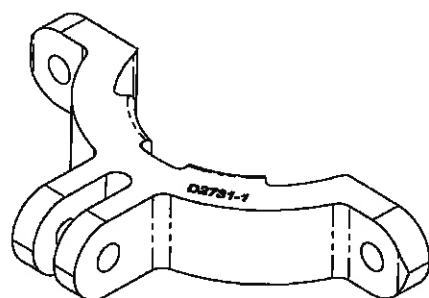
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	4.450Inches $\pm$ 0.010	4.460 4.440		
2	Mounting Lug	1.410Inches $\pm$ 0.030	1.440 1.380		
3	Mounting Lug	0.306Inches $\pm$ 0.010	0.316 0.296		
4	Mounting Lug	0.413Inches $\pm$ 0.010	0.423 0.403		
5	Mounting Lug	3.700Inches $\pm$ 0.005	3.705 3.695		
6	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
7	Mounting Lug	0.750Inches $\pm$ 0.010	0.760 0.740		
8	Mounting Lug	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
9	Mounting Lug	0.100Inches $\pm$ 0.010	0.110 0.090		
10	Mounting Lug	45.000Degrees $\pm$ 0.000	45.000 45.000	Angle	
11	Mounting Lug	0.060Inches + 0.040 - 0.000	0.100 0.060	Radius	

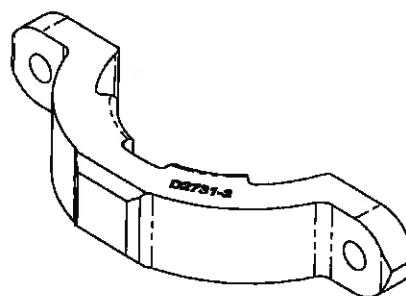
Plex 3/3/20 10:48 AM dart.lacelle.linda

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2624

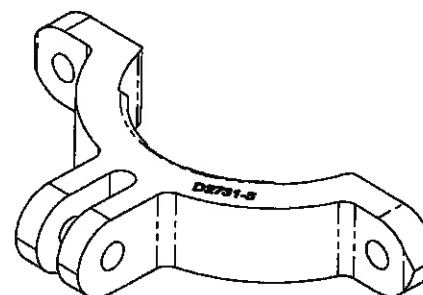
MC
2001-28



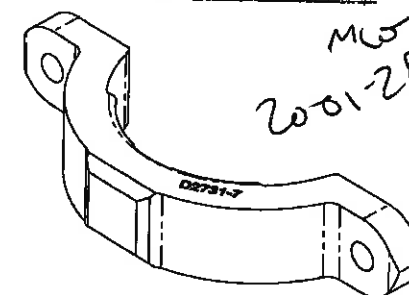
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

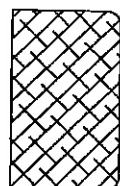
DEO ATTACHED
RELEASED
Chibak

NOTES:

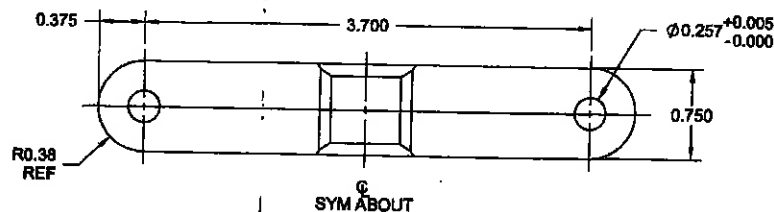
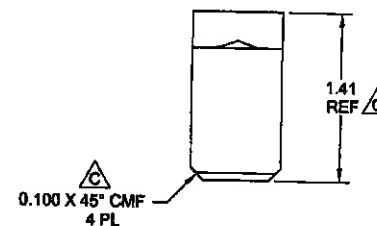
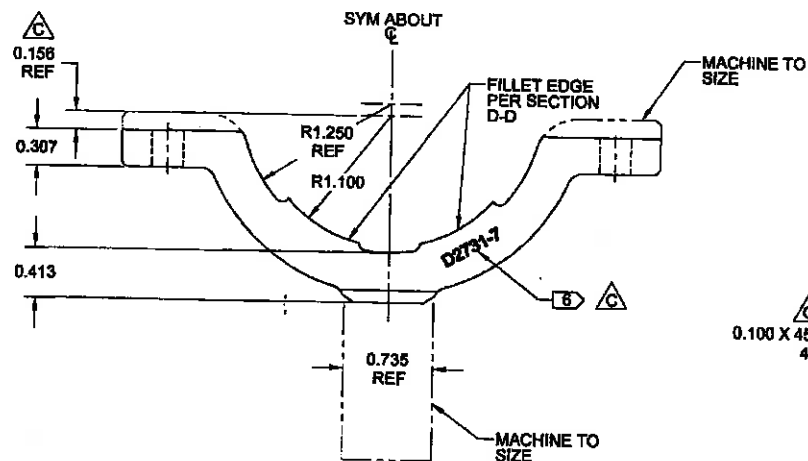
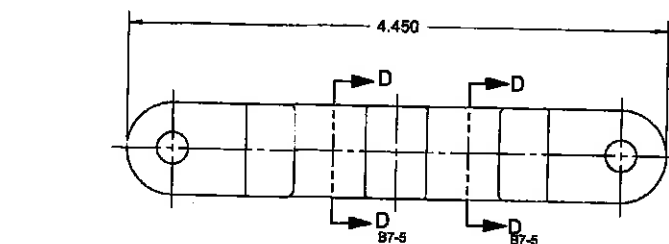
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHIPPING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	09.07.08
A	NEW ISSUE	KE	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SECTION D-D D4-5
SCALE 2X



R0.06 MIN-R0.10 MAX
2 PL



D2731-7 MOUNTING LUG

DEO ATTACHED
RELEASED
09/06/25/19

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	ANS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1986 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE CUSTOMER UNDER THE CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045718



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045718

PO Date: 1/28/20

Due Date: 2/4/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206276	D2731-7P	D2731 Rev.C			Lug : Various STC's receive pcs	Firmed X50	-	2/4/20	50 pcs	0 pcs	50 pcs	\$16.20/pcs	\$810.00
													Grand Total:	\$810.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 1/28/20 4:01 PM dart.lussier.patrick



www.metec.ca | 20 Terry Fox Drive, Van Horne Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 26619
Shipment Date: 28-Jan-2020
Ship Via: Pick up at METEC
Order Number: 4571
Order Date: 01/28/2020

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB045718
Terms: Net 60 Days

Quantity							Revision	Job Number
Item	Open	Shipped	B/O	Canceled	Unit	Description		
1	50	50	0	0	EA	aluminum and painted as per QSI005	C	4571-01

DAS
8
9-89

FEB 04 2020

RECEIVED

JAN 30 2020

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Heather Nip
Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
50	D2731-7	Lug	C	S141186	018942-1	HB045718

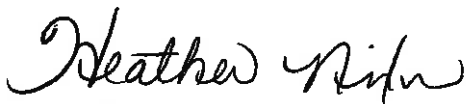
DAS
32
9-89

FEB 04 2020

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Heather Nixon

Vankleek Hill, January 29, 2020



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2731-7
Job Sheet 206276-A



5255138

Part No: D2731-7

Job Qty: 28 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 2/26/20

Description:

Note: DWG REV C IPP D 00.05.19 Added inspect level 8, removed P/O powder coating EC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
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							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
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							Packaging 2 - 11 - B4B	
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							Packaging 2 - 18 - B4B	
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							Packaging 2 - 30 - B4B	
							Packaging 2 - 31 - B4B	
							Packaging 2 - 32 - B4B	



DART
AEROSPACE

Container No: S255138



Part: D2731 – 7
Job No: 206276 – A
Serial No/Batch: S252342

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd,
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL : 1 813 632 – 5205
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/14/20.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S255138



Part: D2731-7

Job No: 206276-A

Serial No/Batch: S252342

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/14/20.

					Packaging 2 - 33 - B4B	
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					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
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 Descriptions: 130 - (QC6- All purchased or subcontracted products)
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10	Mounting Lug	45.000Degrees $\pm$ 0.000	45.000 45.000	Angle	
11	Mounting Lug	0.060Inches $\pm$ 0.040 - 0.000	0.100 0.060	Radius	

Plex 2/12/20 11:52 AM Dart.Renwick.Jennifer



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2731-7

Job Sheet 206276



Part No: D2731-7

Job Qty: 50 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/20

Job Tracking No:

Due Date: 2/26/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP D 00.05.19 Added inspect level 8, removed P/O powder coating EC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

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							Purchasing - 2	
							Purchasing - 3	
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							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	DP JAN 30 2020
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	



Container No: S252342



Part: D2731 - 7
Job No: 206276
Serial No/Batch: S252342
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1276 Aberdeen Street
Newkesbury, ON K54 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/30/20



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1270 Aberdeen Street
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Container No: S252342



Part: D2731-7

Job No: 206276

Serial No/Batch: S252342

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/30/20

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
130 QC 6	50 pcs	2/26/20	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
170 Packaging 3-1 - Stock - B4B	50 pcs	2/26/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180 QC 21 - SA	50 pcs	2/26/20	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 110 - (Purchasing) Issue P/O to Metec : <u>H604571B</u> Manufacture as per dwg C of C is required Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) ENSURE C OF C IS ATTACHED 130 - (QC6- All purchased or subcontracted products) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)						

x 50 *[Signature]* 26 Jan 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	3.4150 ft (.0683 ea)	110-Purchasing	5141186
D2731-7P	Lug	50 pcs (1 ea)	110-Purchasing	5252339

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	3	608	0
	D2731-7P	50	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	4.450Inches ± 0.010	4.460 4.440		
2	Mounting Lug	1.410Inches ± 0.030	1.440 1.380		
3	Mounting Lug	0.306Inches ± 0.010	0.316 0.296		
4	Mounting Lug	0.413Inches ± 0.010	0.423 0.403		
5	Mounting Lug	3.700Inches ± 0.005	3.705 3.695		
6	Mounting Lug	0.375Inches ± 0.010	0.385 0.365		
7	Mounting Lug	0.750Inches ± 0.010	0.760 0.740		
8	Mounting Lug	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
9	Mounting Lug	0.100Inches ± 0.010	0.110 0.090		
10	Mounting Lug	45.000Degrees ± 0.000	45.000 45.000	Angle	
11	Mounting Lug	0.060Inches + 0.040 - 0.000	0.100 0.060	Radius	

Plex 1/28/20 3:16 PM Dart.lajeunesse.marie

Guillaume Gamache-Beauchamp

From: Steven Drouin
Sent: 3 avril 2020 10:24
To: Guillaume Gamache-Beauchamp
Cc: Patrick Duval; Patrick Lussier
Subject: RE: NCR D2731-7

This is not acceptable Sorry

We made these in house many time and never had a issue , the model is perfectly Symmetrical an the step files and drawings models are also .

@patrick :If you want I could re-send the step files to you to give to the supplier

I cannot deviate this , Sorry

Steven

From: Guillaume Gamache-Beauchamp <ggamachebeauchamp@dartaero.com>
Sent: Friday, April 03, 2020 9:36 AM
To: Steven Drouin <sdrouin@dartaero.com>
Cc: Patrick Duval <pduval@dartaero.com>; Patrick Lussier <plussier@dartaero.com>
Subject: FW: NCR D2731-7

From: Guillaume Gamache-Beauchamp
Sent: 27 mars 2020 13:56
To: Steven Drouin <sdrouin@dartaero.com>
Cc: Patrick Duval <pduval@dartaero.com>
Subject: FW: NCR D2731-7

Hello Steven,

If you could please review the following NCR (most recent one, about the symmetry)

Thank you

Guillaume

From: Holly Zhao <hzhao@dartaero.com>
Sent: 18 mars 2020 08:55
To: Guillaume Gamache-Beauchamp <ggamachebeauchamp@dartaero.com>

Cc: Patrick Lussier <plussier@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: RE: NCR D2731-7

Hi Guillaume,
Thank you for the update.
Just a friendly reminder:
Kindly attach a red tag and a copy of the NCR to the quarantined part as applicable
Thanks!
Holly

From: Guillaume Gamache-Beauchamp <ggamachebeauchamp@dartaero.com>
Sent: Wednesday, March 18, 2020 8:02 AM
To: Holly Zhao <hzhao@dartaero.com>
Cc: Patrick Lussier <plussier@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: RE: NCR D2731-7

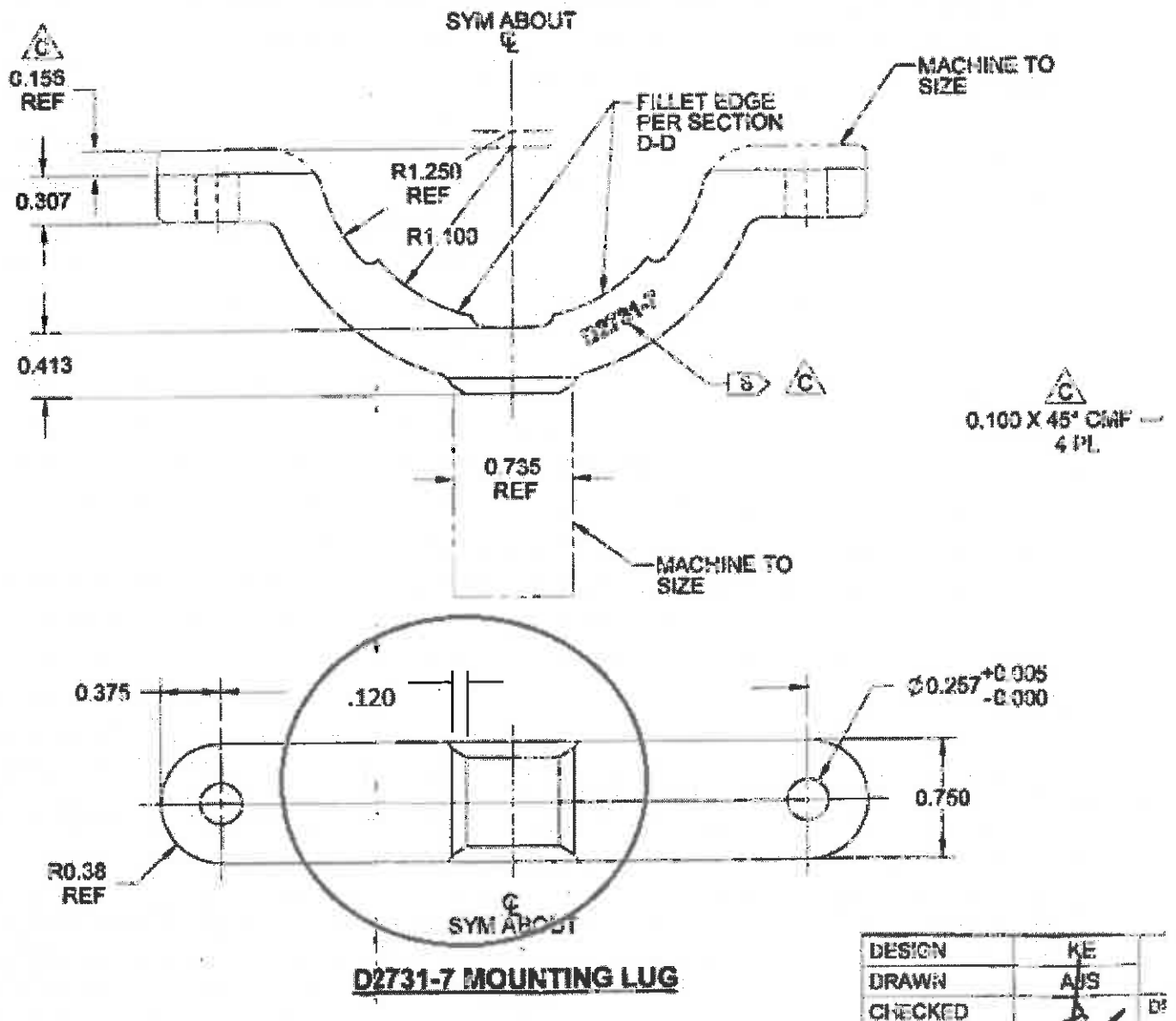
Good morning Holly,

Each sides of the highlighted center part should be .120 , however one side is .065.

I will put in quarantine until Steven tells me if it will affect Fit/Function.

Thank you

Guillaume



-----Original Message-----

From: Holly Zhao <hzhao@dartaero.com>

Sent: 17 mars 2020 16:38

To: Guillaume Gamache-Beauchamp <ggamachebeauchamp@dartaero.com>

Cc: Patrick Lussier <plussier@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>

Subject: RE: NCR D2731-7

Thank you very much Guillaume!

For the new non-symmetric issue, would it be possible to have a measurement? I believe, the QSI018 have certain tolerance for Symmetric. Ex. 0.005.

- 1) how much the symmetric discrepancy?
- 2) Is there any tool to check fitness in house?

It would be appreciated if you could elaborate more to facilitate further review and disposition.

Thanks!
Holly

4
-----Original Message-----

From: Guillaume Gamache-Beauchamp <ggamachebeauchamp@dartaero.com>
Sent: Tuesday, March 17, 2020 3:49 PM
To: Holly Zhao <hzhao@dartaero.com>
Cc: Patrick Lussier <plussier@dartaero.com>
Subject: FW: NCR D2731-7

Hello Holly,

I updated the supplier non-conformance log with a new issue.

Guillaume

-----Original Message-----

From: print.hby@dartaero.com <print.hby@dartaero.com>
Sent: 17 mars 2020 16:48
To: Guillaume Gamache-Beauchamp <ggamachebeauchamp@dartaero.com>
Subject:

=====

Please Open the attached document.

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Date:

DEC 01 2020

DART
AEROSPACE

NCR No.

20-8713-

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

☐

Job: <u>206276-A</u> Part No. <u>02731-7</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☒ Quality ☐																																			
Date : <u>MAR 17 2020</u>		Sequence #: <u>120</u>		QTY Affected : <u>23</u>			MRB (QSI042)																																
Description Work Order Deviation				Disposition				DAS 9 9-89 <u>20-4-14</u> Completed By DAS 82 9-89 <u>MAR 17 2020</u>																															
PART SHOULD BE SYMMETRICAL AT CENTERLINE. THE TRAPEZOID SHAPE ON TOP OF PART IS NOT SYMMETRICAL. DOES THIS AFFECT FIT AND FUNCTION?				Scrap destroy. See attach Email.				Lead hand / Supervisor DAS 9 9-89 <u>20-4-14</u>																															
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☒ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☒ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☒ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☒ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up			
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